

Work Order ID 71395

Thursday, June 30, 2011 12:47:10 PM



Page 1

Item ID: D3272-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step

Start Date: 6/30/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/7/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-06-30

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3272	Rev B								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

SQUARE ONE END BEFORE CUTTING OTHER END

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

He/jk

8

0

11.07.07

110

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 w/07/08



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

11-07-0880

Packaging

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

u/7/11MF
11-07-08

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Picklist Print

Thursday, June 30, 2011 12:47:17 PM

Page 1

Work Order ID: 71395

Parent Item: D3272-1

Parent Item Name: Step




Start Date: 6/30/2011

Required Date: 7/7/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 07-06-09 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C  Step Extrusion		Manufactured	No			100	Each	145.7000	1	8		REU-07-08	

Location

Loc Qty

Loc Code

HALL

132

64409

6

68293

126

WA

13.7

46910

2

66970

11.7

8

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NOTE: Date & initial all entries

DART

DESIGN <i>QD</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED07.06.04 *H*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *71325*

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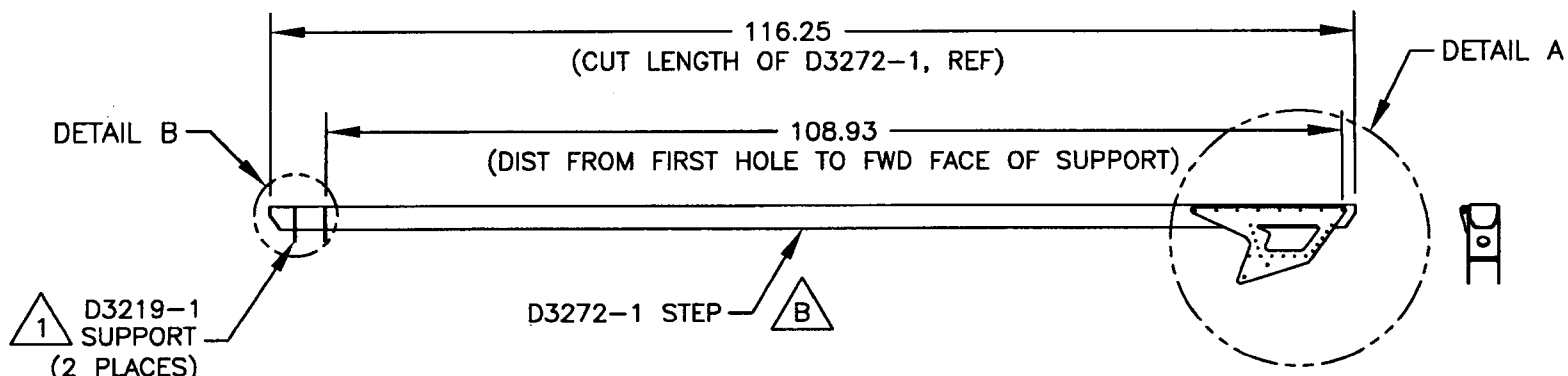
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DART

110.80
136
114.89

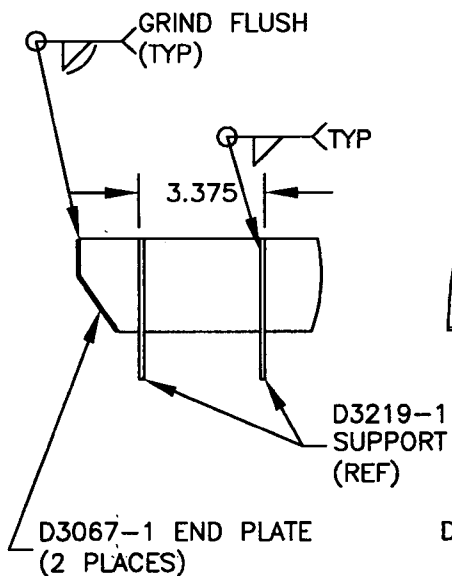
DESIGN	99	DRAWN BY	13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED	13	DRAWING NO. D3272
DATE	07.05.18	TITLE	STEP ASSEMBLY, HI LONG	REV. B
		SCALE	1:20	SHEET 2 OF 3



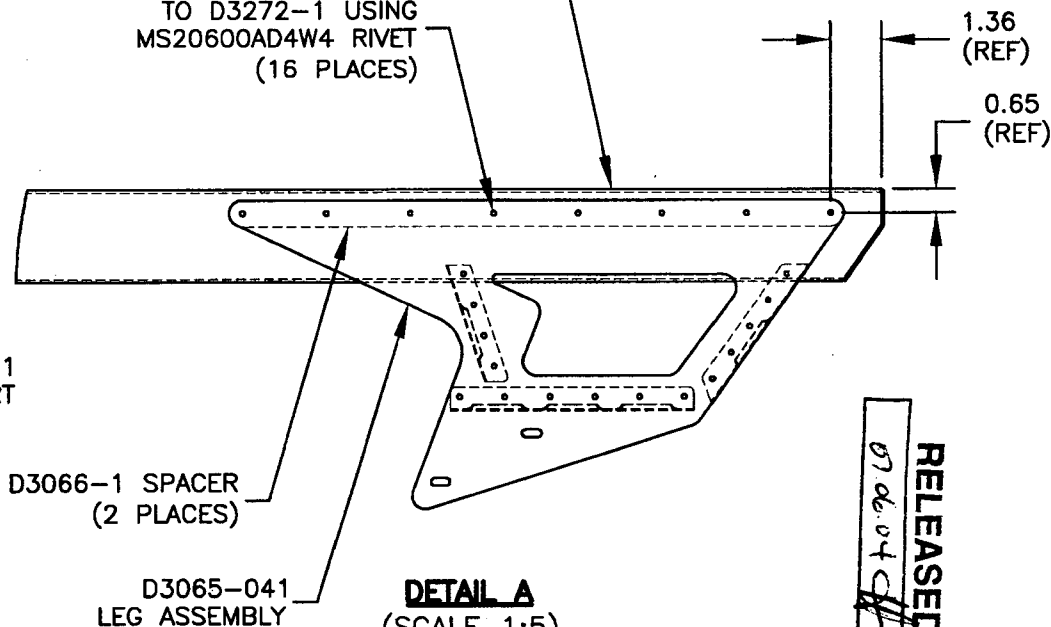
D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)

APPLY BLACK ANTI-SKID
ON TOP SURFACE TO
BOTTOM OF TOP RADIUS

RIVET D3065-041
TO D3272-1 USING
MS20600AD4W4 RIVET
(16 PLACES)



DETAIL B
(SCALE 1:5)



DETAIL A
(SCALE 1:5)

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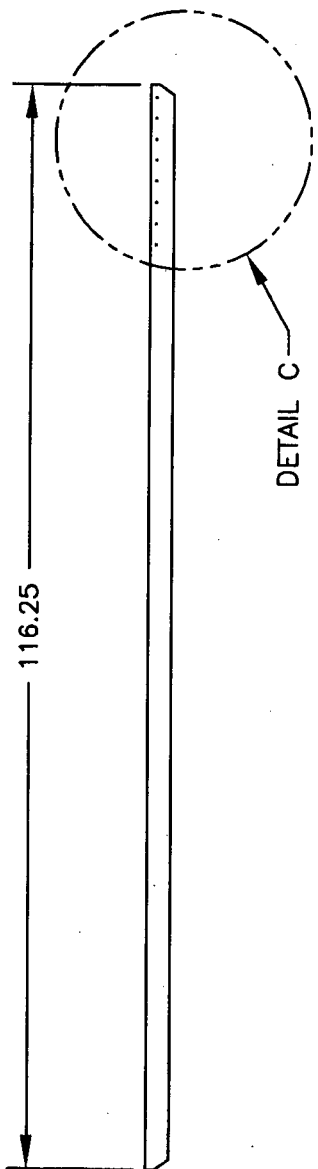
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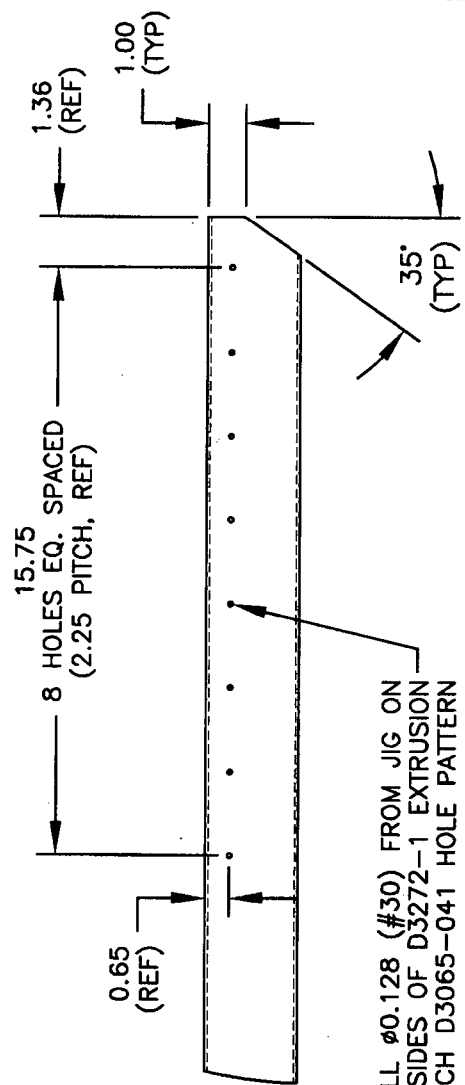
DESIGN <i>GP</i>	DRAWN BY <i>JB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED
07.06.04 *[Signature]*



△ D3272-1 STEP
(MAKE FROM D2622-120 STEP EXTRUSION)

113066



DETAIL C
(SCALE 1:5)

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